

# Work Order ID 122844

July-29-14 2:03:08 PM

**\*122844\***

Page 1

Item ID: D212-664-201TRN

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Crosstube Turning Detail

Start Date: 7/29/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/15/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

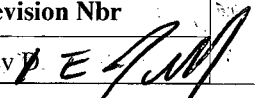
Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-664-241	Rev 

100

0.00

**\*100\***

Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Blend transition lines only. \*\*do not sand whole tube\*\*.

FOLIO REV: AD

DWG REV: D

\*Use mill bastard file, brush file repeatedly with file card.

\*Do not use sandpaper coarser than 320 grit.

110

QC1- Inspect dimensions to dimension sheet

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*mmt*  
14/07/31

*mmt*  
14/07/31

# Work Order ID 122844

**\*122844\***

Page 2

July-29-14 2:03:08 PM

Item ID: D212-664-201TRN Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Crosstube Turning Detail  
 Start Date: 7/29/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/15/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120		0.00							
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<b>*120*</b>	MORI SEIKI CNC LATHE LARGE								
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Mori Seiki	<b>Memo</b>	0.00							
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Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA114								
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2-Blend transition lines only, \*\*do not sand whole tube\*\*:

\*Use mill bastard file, brush file repeatedly with file card.

\*Do not use sandpaper coarser than 320 grit.

FOLIO REV: AD

DWG REV: D

3-Remove sand and plugs

4- scribe batch # and part # as per dwg

130	QC1- Inspect dimensions to dimension sheet	0.00							
-----	--	------	--	--	--	--	--	--	--

<b>*130*</b>									
--------------	--	--	--	--	--	--	--	--	--

QC	<b>Memo</b>	0.00							
----	-------------	------	--	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

*mm L*  
*14/08/01*

*mm L*  
*14/08/01*

**Work Order ID 122844**

July-29-14 2:03:08 PM

**\*122844\***

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Item ID: D212-664-201TRN

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Crosstube Turning Detail

Stop **\*NS2\***

Start Date: 7/29/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/15/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 QC8- Inspect parts - second check

0.00

**\*140\***

QC

Memo

0.00

Quality Control

 14-08-07

145

0.00

**\*145\***


Crosstubes

Memo

0.00

Crosstubes

GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

 14-08-07

150

0.00

**\*150\***

HandFXtube


Memo

0.00

Hand Finishing Crosstubes

1- PRESSURE WASH X-TUBE INSIDE AND OUT

2- ACID ETCH X-TUBE INSIDE AND OUT. USE RED SCOTCH BRITE

 14-8-8  
DMC

# Work Order ID 122844

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**\*122844\***

Page 4

Item ID: D212-664-201TRN Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Crosstube Turning Detail  
 Start Date: 7/29/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/15/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS
160	QC5- Inspect part completeness to step on W/O	0.00								
<b>*160*</b>										
QC	Memo	0.00								
Quality Control										
170	Packaging	0.00								
<b>*170*</b>										
Packaging	Memo	0.00								
Packaging	Identify and stock in kanban rack									
	Location: <u>LG</u>									
180	QC21- Final Inspection - Work Order Release	0.00								
<b>*180*</b>										
QC	Memo	0.00								
Quality Control										

MLJ 14-08-13

# Picklist Print

July-29-14 2:03:08 PM

Page 1

Work Order ID: 122844

**\*122844\***

Parent Item: D212-664-201TRN

**\*D212-664-201TRN\***

Parent Item Name: Crosstube Turning Detail

Start Date: 7/29/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec  
IPP Rev B 08.04.02 Removed polish EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6006-129		Manufactured	No			120	Each	29.0000	1	1			

**\*D6006-129\***

Crosstube Material

**\*\***

Location

Loc Qty

Loc Code

LG003

29

103426

10

107875

18

75644

1

1 mmm 14/07/30

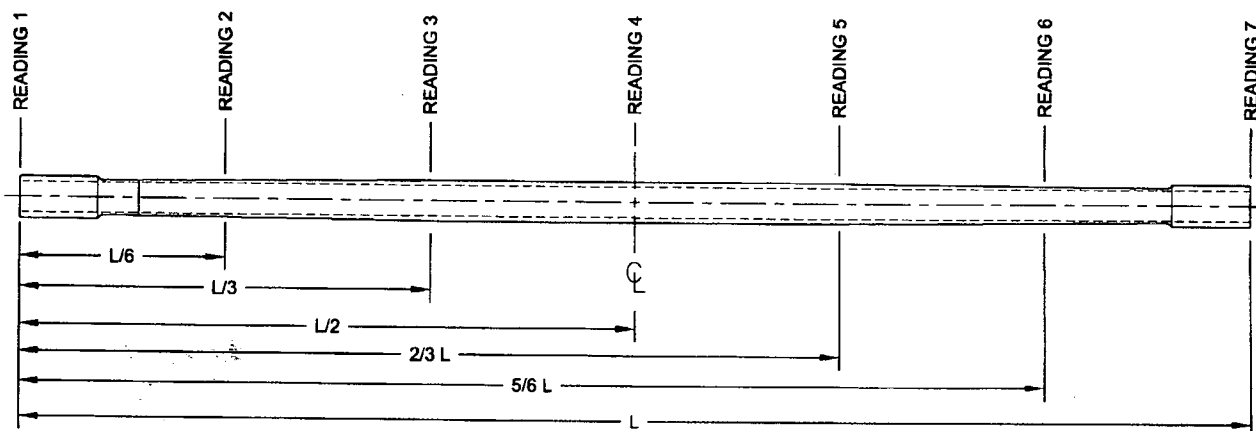
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	122844
<b>Description:</b> Crosstube Assembly (205/212 High Aft)		<b>Part Number:</b>	D212-664-241
<b>Inspection Dwg:</b> D212-664-241 Rev: <i>PE401</i>		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.200	/		vern	CNC-08
	R0.063	+/-0.010	.063	/		RG	
	2.990	+0.005/-0.000	2.991	/		vern	CNC-08
	5.237	+/-0.030	5.240	/			
	2.600	+0.005/-0.000	2.604	/			
	2.686	+0.005/-0.000	2.690	/			
	2.770	+0.005/-0.000	2.773	/			
	2.854	+0.005/-0.000	2.857	/			
	2.938	+0.005/-0.000	2.941	/			
	3.021	+0.005/-0.000	3.023	/		mic	CNC-05
	3.133	+0.005/-0.000	3.136	/			
	3.179	+0.005/-0.000	3.182	/			
SIDE B	0.200	+/-0.010	.200	/		vern	CNC-08
	R0.063	+/-0.010	.063	/		RG	
	2.990	+0.005/-0.000	2.992	/		vern	CNC-08
	5.237	+/-0.030	5.240	/			
	2.600	+0.005/-0.000	2.603	/			
	2.686	+0.005/-0.000	2.690	/			
	2.770	+0.005/-0.000	2.774	/			
	2.854	+0.005/-0.000	2.857	/			
	2.938	+0.005/-0.000	2.940	/			
	3.021	+0.005/-0.000	3.023	/		mic	CNC-05
	3.133	+0.005/-0.000	3.136	/			
	3.179	+0.005/-0.000	3.183	/			
	124.362	+/-0.020	124.360	/		tape	LG-11

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 12284
<b>Description:</b> Crosstube Assembly (205/212 High Aft)		<b>Part Number:</b> D212-664-241
<b>Inspection Dwg:</b> D212-664-241 <b>Rev:</b> D		<b>Page 2 of 2</b>

### WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation $\Delta w$ (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	.401	.397	.393	.391	.010	0.062"
READING 2 L = 20.5	.329	.347	.294	.280	.067	
READING 3 L = 41.5	.497	.476	.481	.487	.019	
READING 4 L = 62	.517	.503	.528	.539	.036	
READING 5 L = 82.5	.498	.474	.486	.499	.025	
READING 6 L = 103.5	.312	.294	.333	.341	.047	
READING 7 L = 124.362	.394	.384	.396	.407	.023	

Dwg  $\Delta$   
0.304 0.024

#### Calibration Result

Actual Block Thickness: .060 .750

Sitiescan 250 Measured Thickness: .100 .750

<b>Measured by:</b> gmm.L	<b>Audited by:</b> JN	<b>Preliminary Approval:</b>
<b>Date:</b> 11/08/01	<b>Date:</b> 14-08-14	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	
E	12.06.04	Wall thickness form added	KJ	

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2		D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6		2	D5018-1	SUPPORT
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH = 124.362±0.020
- 2) FINISH: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)  
d) PAINT OUTSIDE PER DART QSI 005 4.2  
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-241/-241B = 44.2 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

#### MACHINING

- 10) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

#### BENDING

- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- 12) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 036.

#### ASSEMBLY

- 13) INSTALL D2940-1 / D5018-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 14) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

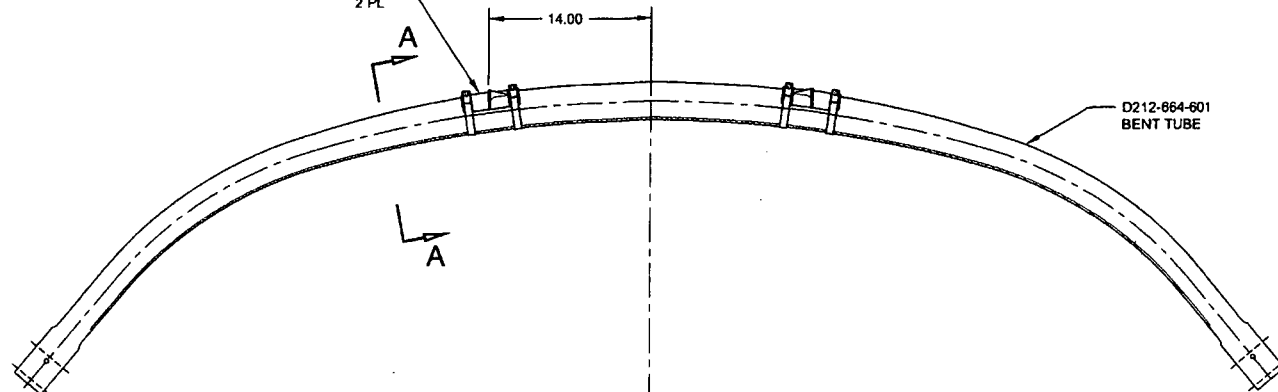
E	D5018-1 WAS D2940-1 (-241B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (ZN B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-4), INCORP DEO D-1/-2	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS: ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-048 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	9	DART AEROSPACE LTD	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DW	DRAWING NO.	REV. E
MFG. APPR.	TH	D212-664-241	SHEET 1 OF 5
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED  
2014-05-26



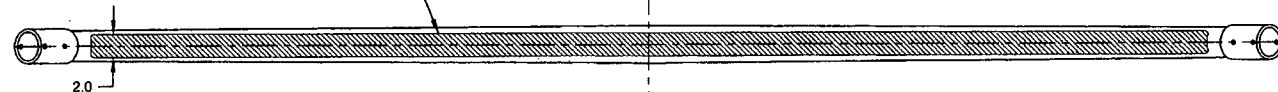
8 7 6 5 4 3 2 1

13 14 15  
 D2940-1 SUPPORT  
 MS21920-28 CLAMP, 2X  
 D3595-063-530 RUBBER CUSHION, 2X  
 2 PL



D212-664-601  
 BENT TUBE

MASK AREA PRIOR TO PAINTING,  
 REMOVE MASKING AFTER PAINT  
 AND APPLY CLEAR COAT

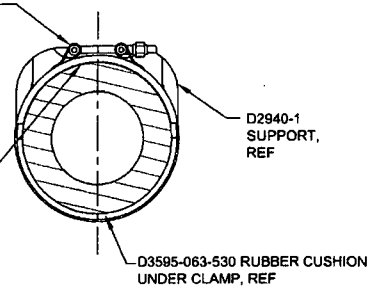


SYM

**D212-664-241  
 ASSEMBLY DETAIL**

E MS21920-28  
 CLAMP, REF  
 14 15

E 13  
 APPLY PROSEAL  
 BETWEEN D2940-1 AND  
 CROSSTUBE

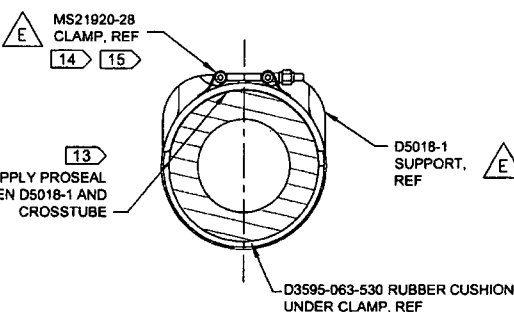
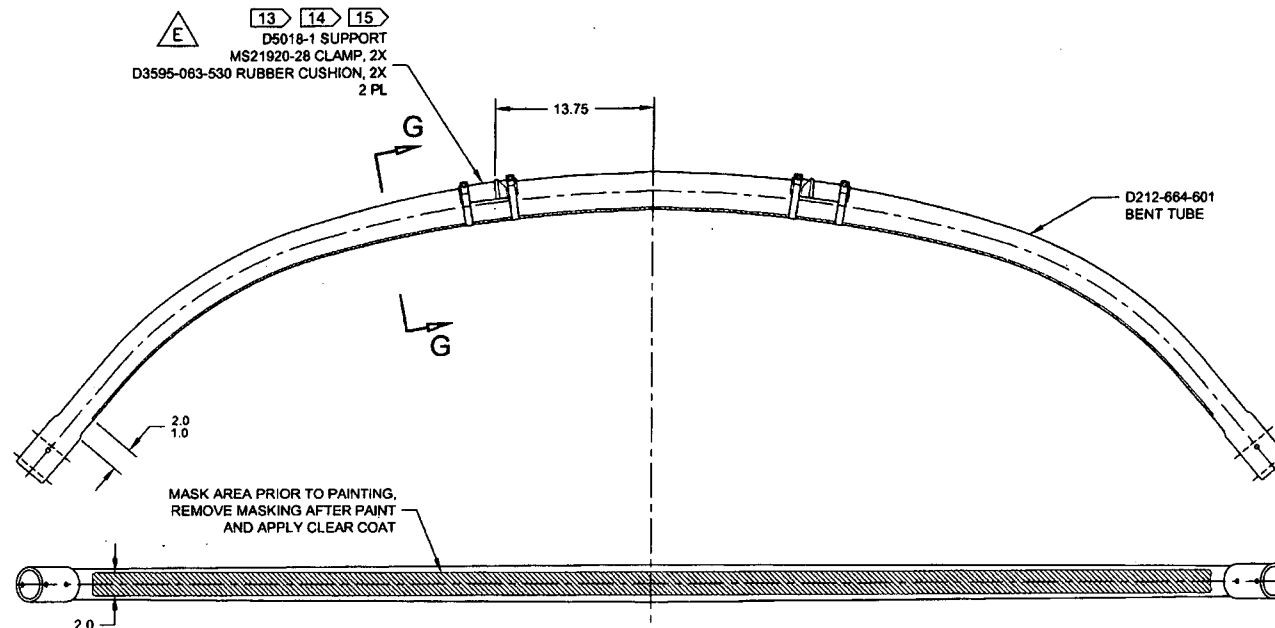


**SECTION A-A  
 SCALE 4X**

**RELEASED**  
 2014-05-26

DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SL	DRAWING NO.	REV. E
MFG. APPR.	SL	D212-664-241	SHEET 2 OF 5
APPROVED	SL	TITLE	SCALE
DE APPR.	SL	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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8 7 6 5 4 3 2 1

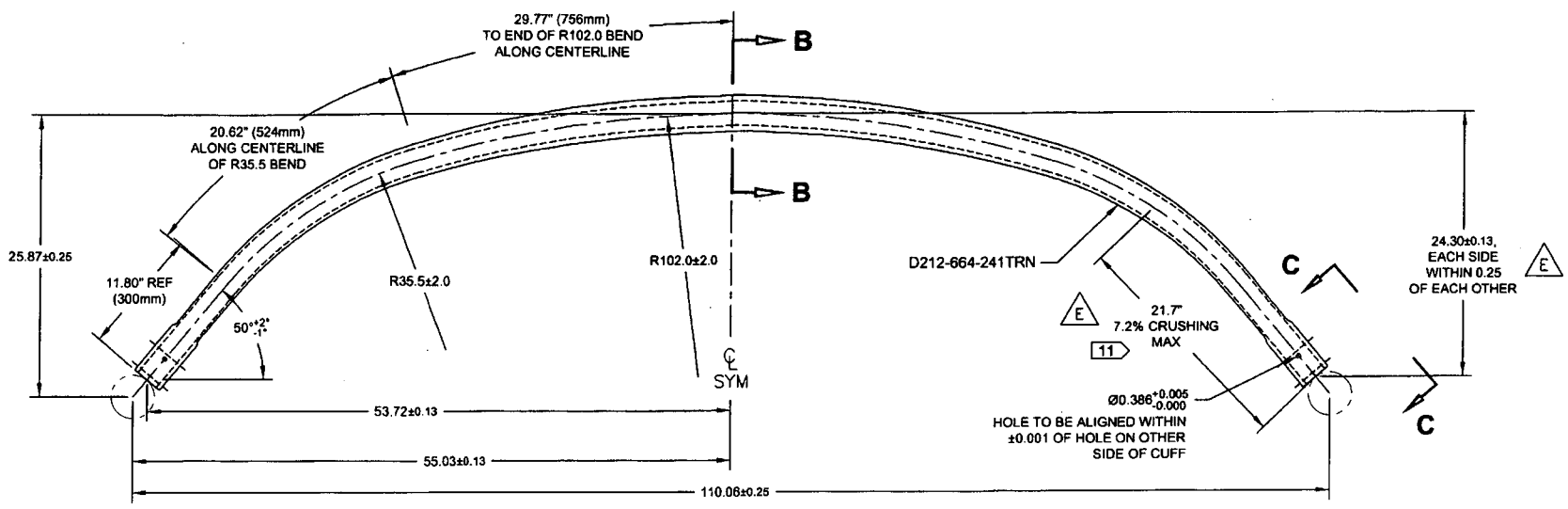


**SECTION G-G**  
SCALE 4X

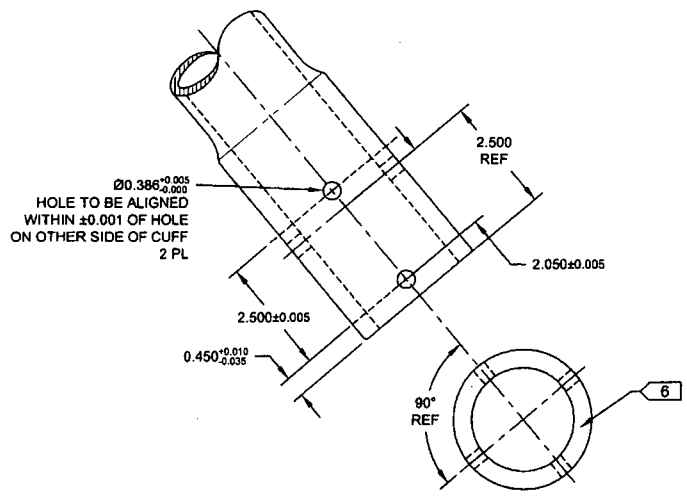
**D212-664-241B**  
**ASSEMBLY DETAIL**

RELEASED  
2014-05-26

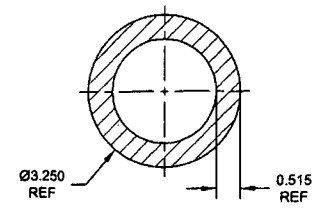
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DRAWN	P	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DW	DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 3 OF 5
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**D212-664-601** 11  
**BENDING AND DRILLING DETAIL**



**VIEW C-C: CUFF DETAIL**  
 SCALE 3X



**SECTION B-B**  
 SCALE 4X

**RELEASED**  
 2014-05-26  
 JMD

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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•NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

DQA:                      Date: 14/08/27

QA Closed:                      Date: 14/8/27

Work Order: <u>122844</u> Part No. <u>D212-664-20121</u> NCR No. <u>1A-4192</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> Skid-tube <input type="checkbox"/> Crosstube <input checked="" type="checkbox"/> Water Jet <input type="checkbox"/> Engineering <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Quality <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Other <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> Supplier <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input checked="" type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	14/8/27	100	1	Ultrasonic wall measurement is over tolerance. Min wall = 0.280 Avg = 0.304 Re. Process -	DAS 12 989 14/8/27	Acceptable. Min wall is within allowable of raw mat'l	DAS 12 989 14/8/27	JW 14-08-07	S 14/08/07

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input checked="" type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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